

Date: Wednesday, 02/04/2008 3:39:38 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CROSSTUBE EXTRUSION (407 AFT)		
Job Number	: 38343			Part Number	: D6010115		
Estimate Number	: 10031			Drawing Number	: D6010 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/04/2008	S.O. No.	:	Drawing Revision	: A		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: LANDING GEAR	Due Date	: 20/11/2008		
Previous Run	: 32308			Qty:	45	Um:	Each
Written By	:			Comment	: Est Rev:A 01.08.17 New Issue SM		
Checked & Approved By	: <u>JO 08.4.03</u>						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: <u>6064</u> <u>C208/04/04 R 45</u> a) Order as per Dwg D6010 b) Material: 2.250 x 0.320 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube c) Minimum ultimate tensile strength = 77 ksi d) Minimum tensile yield strength = 66 ksi e) Tolerance are per ASTM B210 (see details on Dwg D6010) f) Material certification required		

2.0	D6010115P	Crosstube Material	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 45.0000 Each(s) Crosstube Material			

3.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached			

4.0	QC6	DIMENSIONAL CHECK	
Comment: DIMENSIONAL CHECK Ensure Material certification comply to Dwg			

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

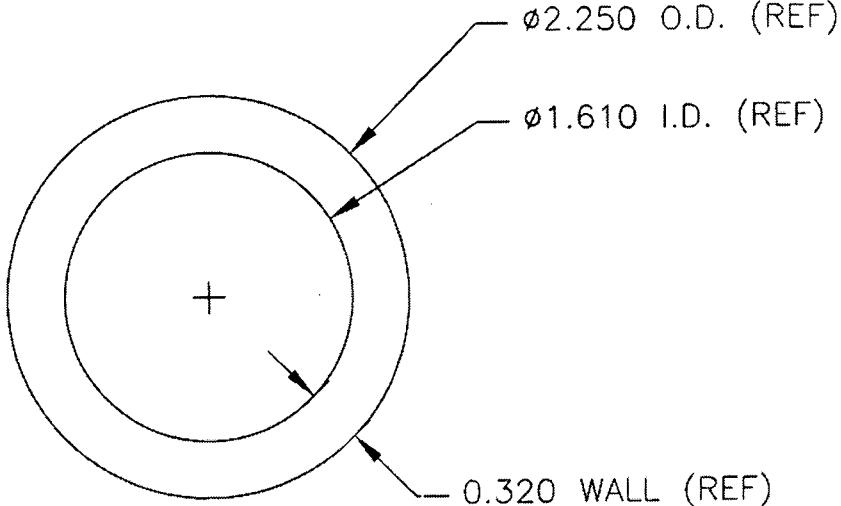
NOTE: Date & initial all entries



DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D6010	REV. A SHEET 1 OF 1
DATE 01.08.16	TITLE CROSSTUBE MATERIAL		SCALE 1:1
A	01.08.16	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.08.17 *RF*



NOTES

1) D6010-XXX CROSSTUBE

LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 115" LONG TUBE: D6010-115

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38373

- 2) MATERIAL: 2.250 OD x 0.320 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.006 MEAN (± 0.012 INCLUDING OVALITY)
WALL: ± 0.015 MEAN (± 0.032 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.125/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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Packinglist AL.Unna AG

Customer PO	PO. 0006064
ALUnna ref. no.	29105/4
Date:	09.25.08

We hereby declare that the wooden packing material are totally free from bark and apparently free from live plant pests

Boxmarking:

Dart-Aerospace PO. 00006064
D 6010-115 Made in Germany
Dest. Hawkesbury Ont. Canada

Abnahmeprüfzeugnis 3.1 - EN 10204:2004

Inspection Certificate 3.1 - EN 10204:2004 / Certificat de Reception 3.1- EN 10204:2004

Kunde: Dart Aerospace Ltd.

Client:

1270 Aberdeen Street
K6A1K7 Hawkesbury, ON Canada

Zeugnisnummer: 1452/08

Cert No. / No. du certificat:

PO00006064

Produkt: Rohre nahtlos gepresst

Product / Produit: Tubes seamless extruded

Spezifikation: AMS - QQ - A - 200/11E;

Specification:

Werkstoff: 7075

Alloy/Alliage:

Abmessung: 2,250 INCH x 1,610 INCH x 0,320 INCH x 115,000 INCH
Size / Dimension D6010-115

Bestellnummer:

Order No. / No. de commande:

29105/4

Auftrag:

Our Reference/Notre Reference:

Kennzeichnung:

Marking/Marquage: ALUnna - Cert No. 1452/08 - 7075 - T 6511 - Cast No. 81744 - AMS - QQA 200/11 E - 2.250" OD X 0.320" Wall - Heat Lot No. 1859 - ALUnna Order Conf. No. 29105/4-1 PO. 00006064

Zustand: T 6511
Temper/État

Lieferung:

Delivered Material / Matériel délivré:

pcs.

lbs

43

977

Country of Manufacture: Germany

1. Chemische Analyse

Chemical Analysis / analyse chimique

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	Ni
Charge/ Cast No.	min.											
	max.	0,40	0,50	1,2	0,30	2,1	0,18	5,1				
81744		0,06	0,13	1,35	0,04	2,47	0,18	5,83	0,04	0,01	0,03	0,01

Hydrogen content: 0,10

ccm/100 g Al

Elements without indication < 0,01 %

country of melt manufacturer: Germany

2. Mechanische Eigenschaften

Mechanical Properties / Valeurs Mécaniques

Anforderungen Requirements	tensile (Rm) ksi	yield (Rp0,2) ksi	elongation 2" %	elongation A %	Hardness HB	Heat Lot No.
	min. max.	81,0	73,0	7,0		
1	86,565	79,750	9,0			1859 - 43 pcs.

*S
06/02/03*

RMS outside 25 - max. 11,5 μ "

**Ergebnis der
Prüfungen:** Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

Test results:

We confirm that the delivery has been tested and applies to the agreements made on receipt of the order

Resultats:

Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande